

Work Order ID 72643

Wednesday, August 03, 2011 1:54:54 PM



Page 1

Item ID: D4271-027

Accept



Setup Start



Revision ID:

Stop



Item Name: End Fitting Assembly Aft Beam

Start Date: 8/3/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/8/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

W

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4271

D

100

0.00



Small Fab

Memo

0.00

Small Fab

Assemble as per dwg D4271
REAM HOLE AS PER DWG
CUT RIVET AT 1.130"
C' SINK AT .220" X100 DEG FOR HOLE OPPOSITE TO HEAD

9/11/08/10 *(U)*

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sulostiz

(H)

120

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

Line for D407-997-111 Kit

Packaging

used on w/o 72652

W

D4127-013

Work Order ID 72643

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Item ID: D4271-027

Accept



Setup Start



Revision ID:

Stop



Item Name: End Fitting Assembly Aft Beam

Start Date: 8/3/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/8/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 11/08/12

MF
11-08-12

Picklist Print

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Work Order ID: 72643

Parent Item: D4271-027

Parent Item Name: End Fitting Assembly Aft Beam






Start Date: 8/3/2011

Required Date: 8/8/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP revA 11.07.20 new issue EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4148-3  Stud Receiver, Lower		Manufactured	No			100	Each	10.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST133		10							
					69616	4							
					70856	8							
D4148-5  Eyebolt Stud		Manufactured	No			100	Each	2.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST133		2							
					69733	2							
* D4281-3  Spacer		Manufactured	No			100	Each	0.0000	1	1			
D4419-3  Aft Support Plate		Manufactured	No			100	Each	0.0000	2	2			
AN4C13A  BOLT		Purchased	No			100	Each	53.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST357		53							
					117793	3							
					118451	50							

B 67733

①

①

B 67736

①

B 72684 ①

B 72683

①

2

Picklist Print

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Page 2

Work Order ID: 72643

Parent Item: D4271-027

Parent Item Name: End Fitting Assembly Aft Beam

Start Date: 8/3/2011

Required Date: 8/8/2011

Start Qty: 1.00

Required Qty: 1.00

MS20427M4-20 Purchased
RIVET

No

100

Each

186.0000

1

1

Location

Loc Qty

Loc Code

ST318

186

118429

186

Each

463.0000

10

MS20615-4M18 Purchased
Rivet

No

Location

Loc Qty

Loc Code

ST323

463

117411

93

118077

370

MS21043-4 Purchased
Nut

No

100

Each

1,057.000

2

2

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

1017

117601

31

117793

486

118378

500

NAS1149C0432R Purchased
Washer

No

100

Each

4,800.000

4

4

Location

Loc Qty

Loc Code

ST297

4800

116900

182

117291

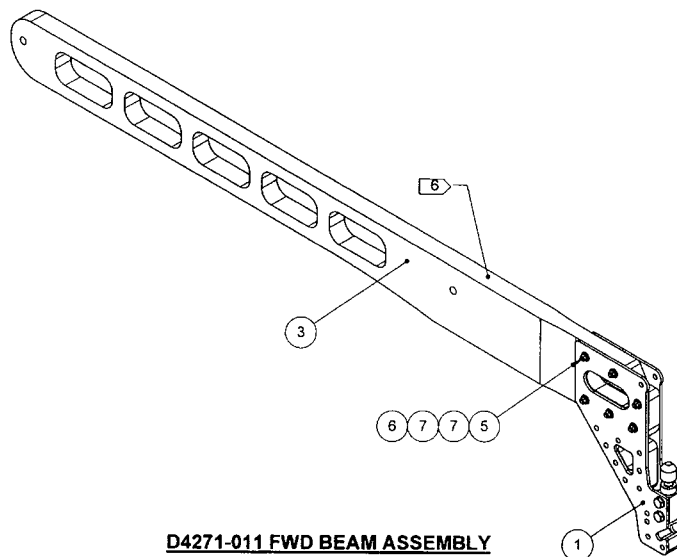
4618

Wednesday, August 03, 2011 1:54:51 PM

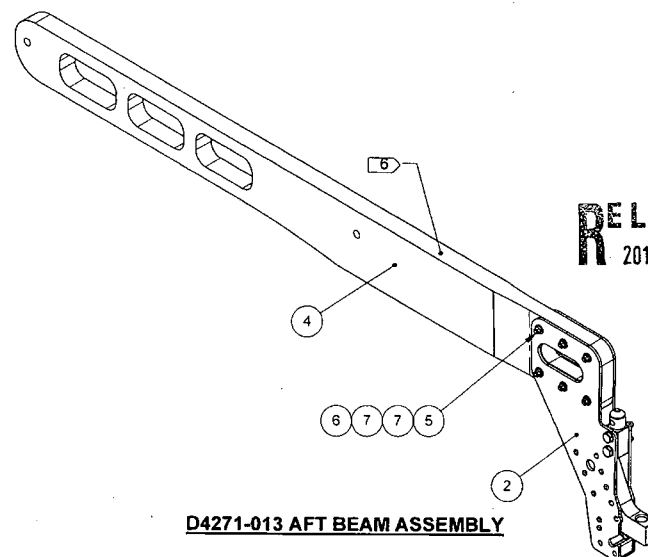
Shop Packet Print

Page 2

ITEM	QTY -011	QTY -013	P/N	DESCRIPTION
	X		D4271-011	FWD BEAM ASSEMBLY
		X	D4271-013	AFT BEAM ASSEMBLY
	-	-	D4271-021	DELETED AT REVISION D
	-	-	D4271-023	DELETED AT REVISION D
1	1	-	D4271-025	FWD BEAM END FITTING ASSEMBLY
2	-	1	D4271-027	AFT BEAM END FITTING ASSEMBLY
3	1	-	D4275-1	FWD BEAM
4	-	1	D4276-1	AFT BEAM
5	6	6	AN3C12A	BOLT
6	6	6	MS21043-3	NUT
7	12	12	NAS1149C0332R	WASHER



D4271-011 FWD BEAM ASSEMBLY



D4271-013 AFT BEAM ASSEMBLY

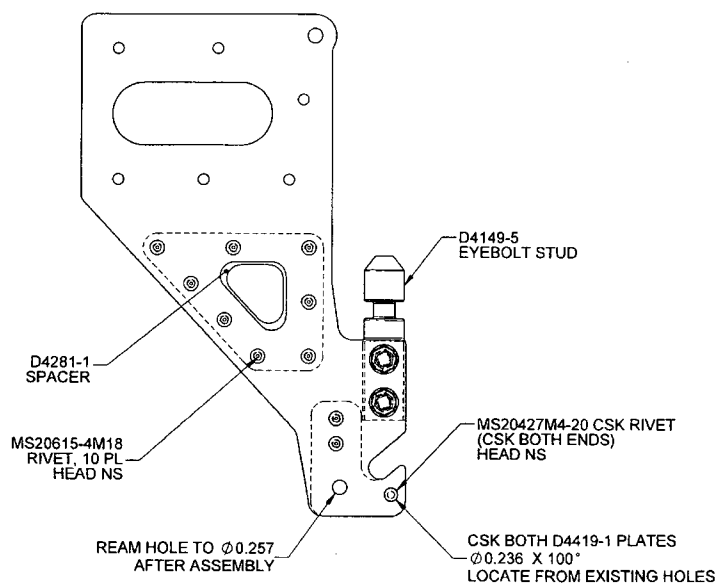
RELEASED
2011-07-28

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART IDENTIFY WITH DART P/N "D4271-0XX" AND B/N "BXXXXX" PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT -011: 11.02 lbs
-013: 12.97 lbs

D	DELETED -021 & -023 REPLACED BY -025 & -027 FOR Q.R. STEP INSTALLATION.	AJS	11.07.14
C	ADDED -021 & -023 FOR EASE OF CONFIGURATION MANAGEMENT. REFORMAT SEE PREV REV FOR DETAILS.	AJS	11.07.12
B	ITEM 10 CHANGED FROM AN3C12A TO AN4C13A	SC	10.12.01
A	NEW ISSUE	SC	10.11.25
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D4271	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SUPPORT BEAM ASSEMBLIES	NTS
DATE	11.07.14	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR CONVEYED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

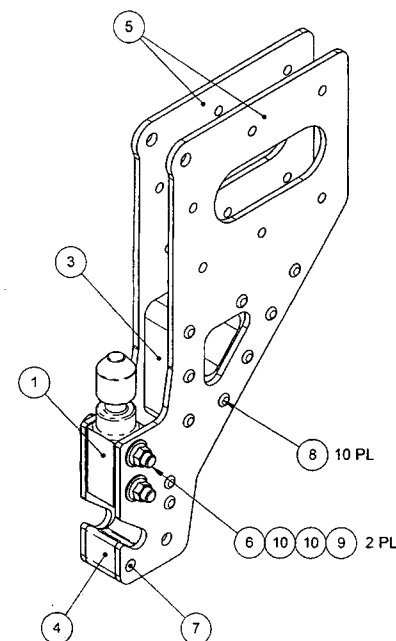
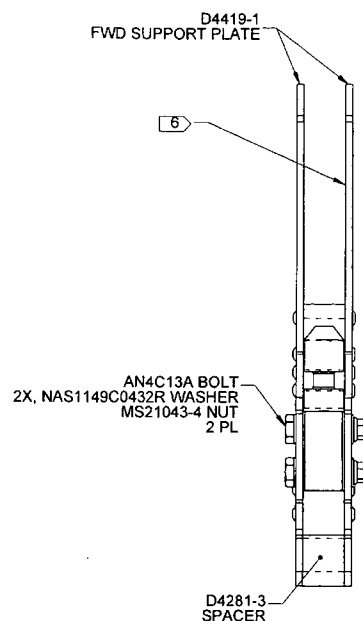
ITEM	QTY -025	P/N	DESCRIPTION
	X	D4271-025	FWD BEAM END FITTING ASSEMBLY
1	1	D4149-5	EYEBOLT STUD
3	1	D4281-1	SPACER
4	1	D4281-3	SPACER
5	2	D4419-1	FWD SUPPORT PLATE
6	2	AN4C13A	BOLT
7	1	MS20427M4-20	CSK RIVET (MONEL)
8	10	MS20615-4M18	RIVET (MONEL)
9	2	MS21043-4	NUT
10	4	NAS1149C0432R	WASHER



D4271-025 FWD BEAM END FITTING ASSEMBLY

NOTES:

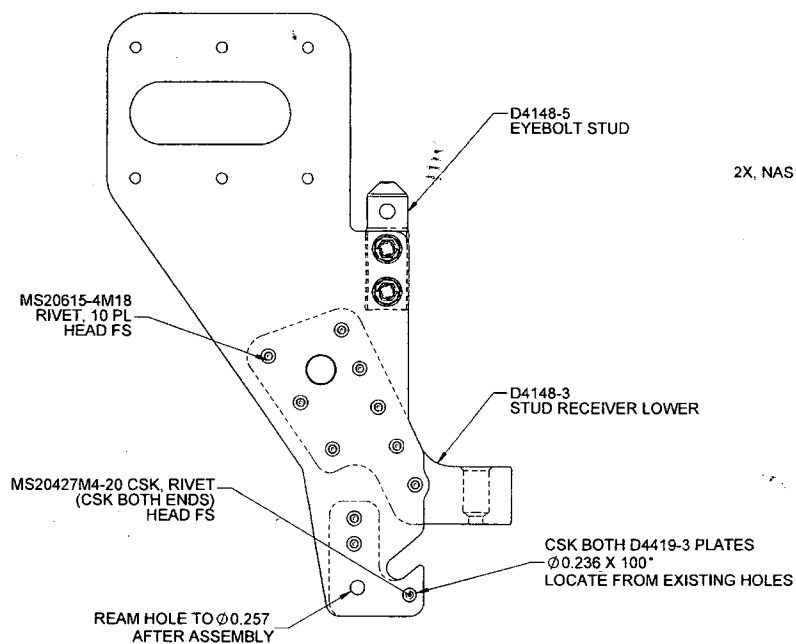
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART IDENTIFY WITH DART P/N "D4271-025" AND B/N "BXXXXX" PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT: 2.69 lbs



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2011-07-28
JN

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4271	SHEET 2 OF 3
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DE APPR.		SUPPORT BEAM ASSEMBLIES	NTS
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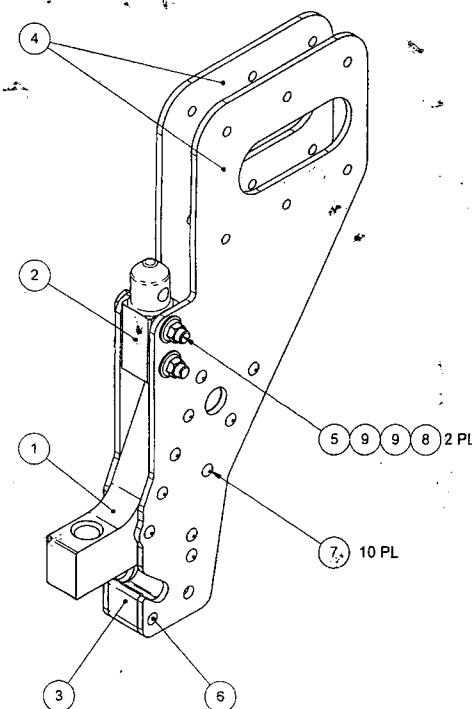
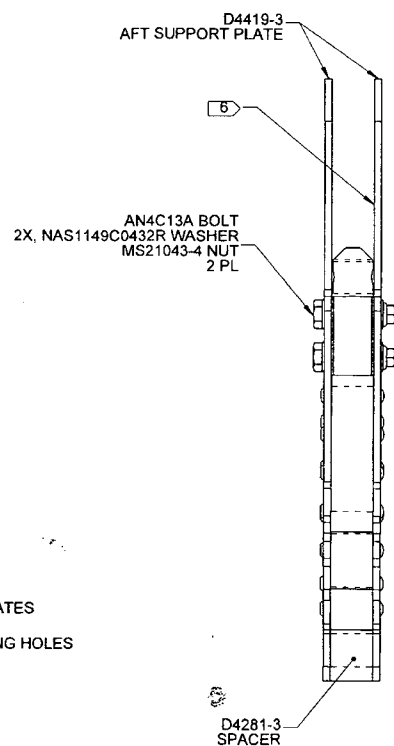
ITEM	QTY -027	P/N	DESCRIPTION
	X	D4271-027	AFT BEAM END FITTING ASSEMBLY
1	1	D4148-3	STUD RECEIVER LOWER
2	1	D4148-5	EYEBOLT STUD
3	1	D4281-3	SPACER
4	2	D4419-3	AFT SUPPORT PLATE
5	2	AN4C13A	BOLT
6	1	MS20427M4-20	CSK RIVET (MONEL)
7	10	MS20615-4M18	RIVET (MONEL)
8	2	MS21043-4	NUT
9	4	NAS1149C0432R	WASHER



D4271-027 AFT BEAM END FITTING ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART IDENTIFY WITH DART P/N "D4271-027" AND B/N "BXXXXX" PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT: 4.25 lbs



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APPROVED		TITLE	SCALE
DE APPR.		SUPPORT BEAM ASSEMBLIES	NTS
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